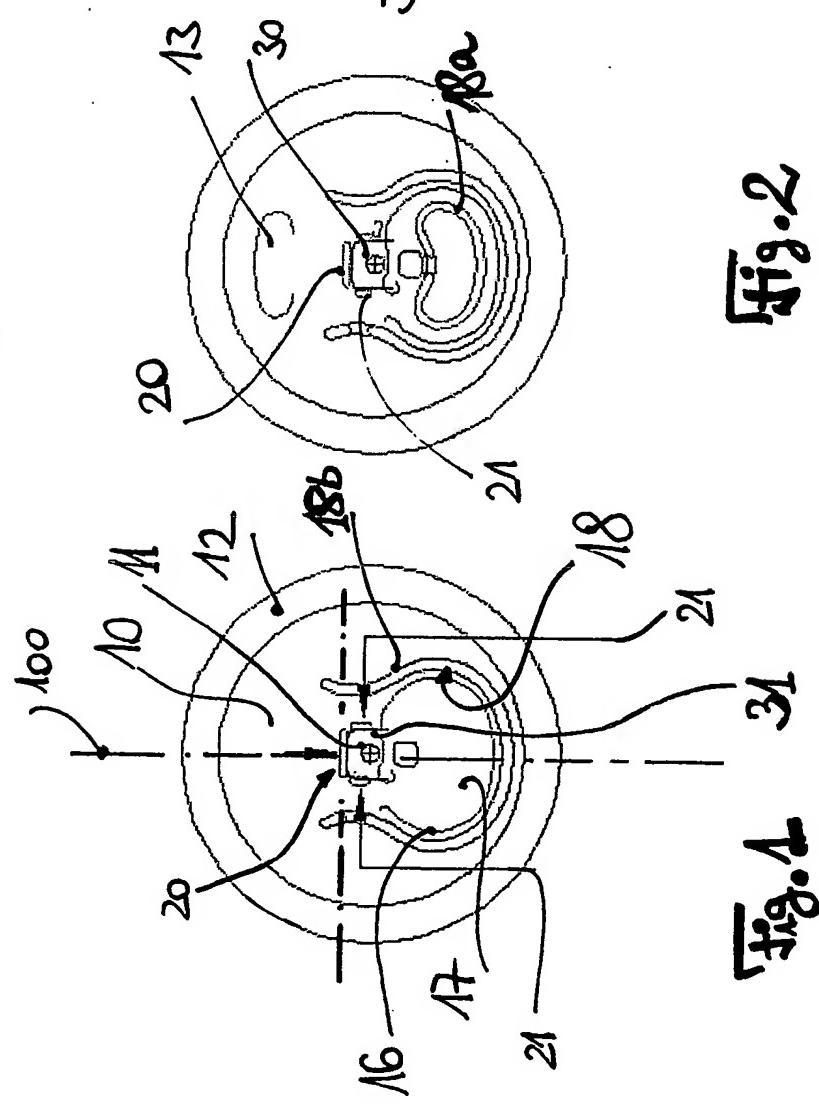


Introduce score line(*)



(*) here or in the
station of Fig. 2

Fig. 1

Form inner bead,
re-form bead,
form fingerwell

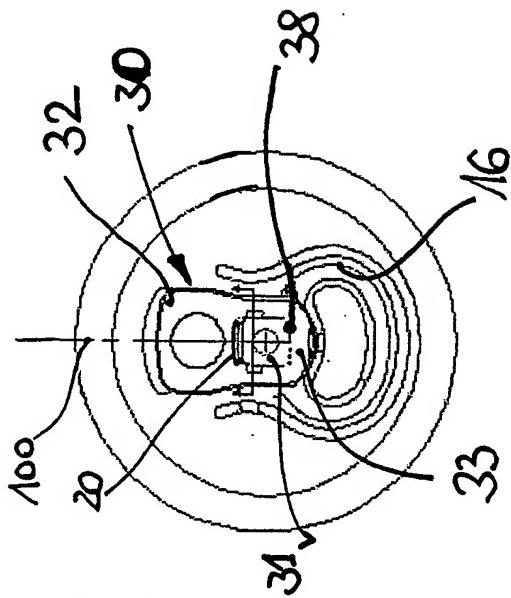


Fig. 2

Staked end
(tab riveted and
positioned)

1/4

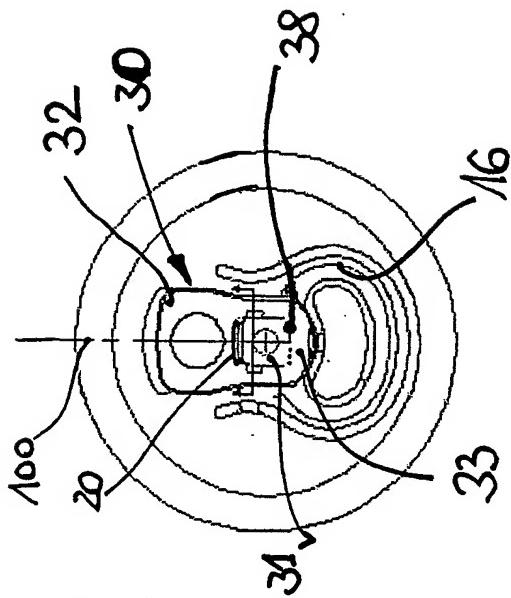


Fig. 3

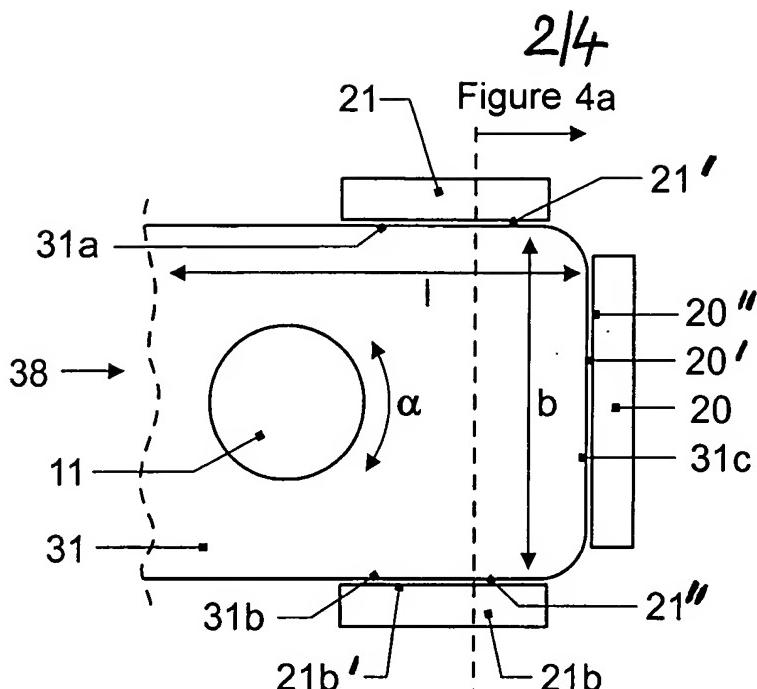


Figure 4

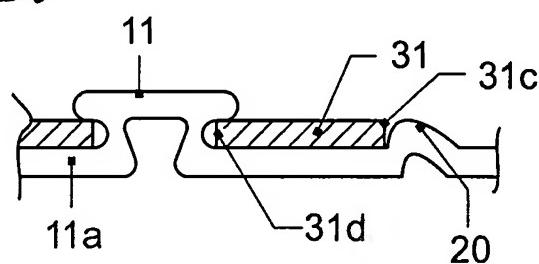
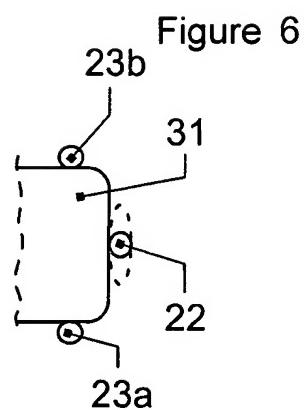
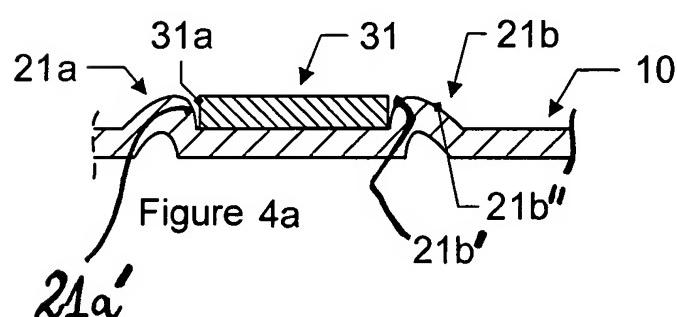
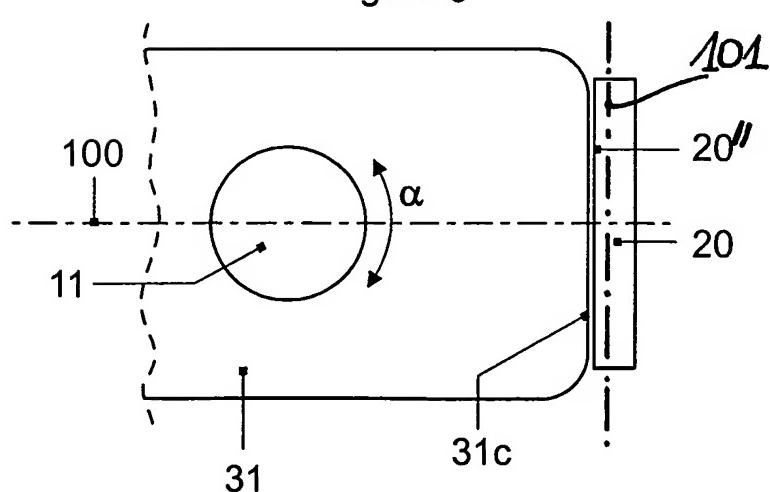
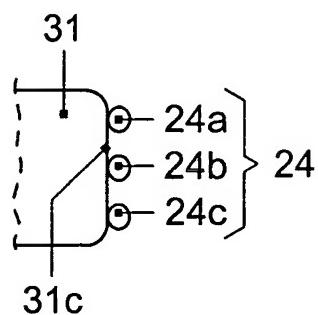


Figure 5



3/4

Figure 8

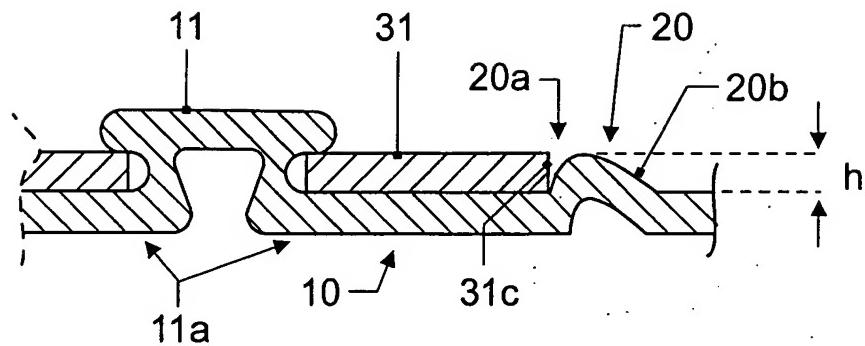


Figure 9a

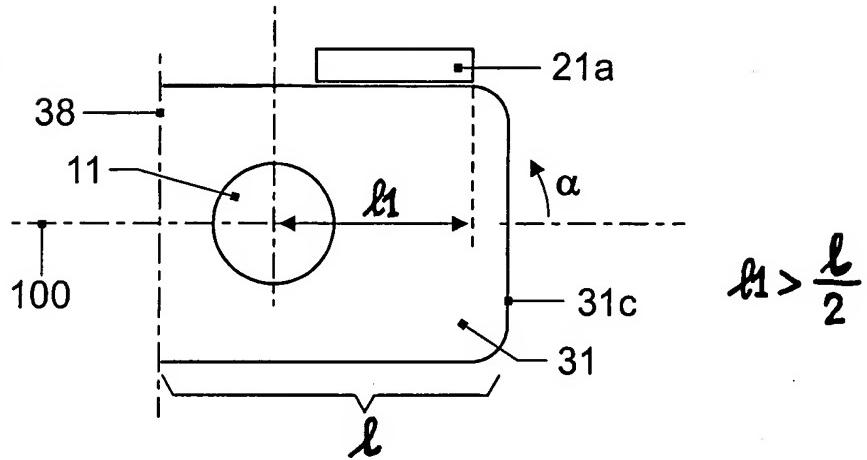


Figure 9b

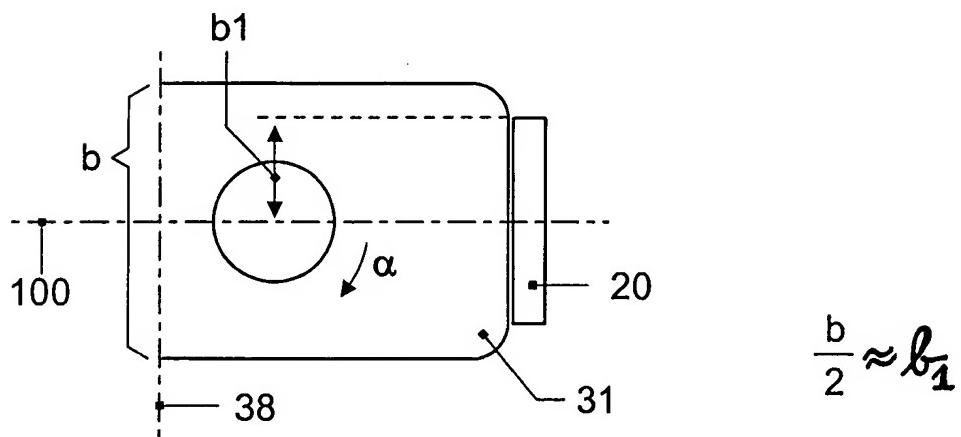
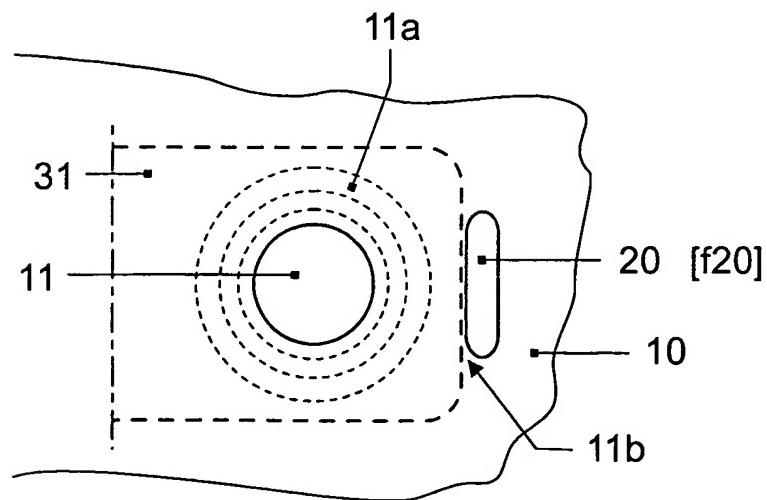


Figure 10



4/4



Fig. 8a